Work Order ID 54807 - 1



Page 1

Insp.

Stamp

December 22, 2009 1:25:42 PM D3703-1 Item ID: Accept Setup Start **Revision ID:** Stop Aft Doubler Item Name: **Start Date:** 1/05/10 Start Qty: 5.00 **Cust Item ID:** Req'd Qty: 6.00 Required Date: 1/15/10 **Customer:** Reference: Start Run Date: 09/12/23 Tooling: Approvals: Process Plan: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Reject Plan Set Up/ Draw Draw Accept Reject Work Center ID Description Qty Qty Number Rev. Code **Run Hours** Number **Revision Nbr Draw Nbr** D3703 Rev A Mer HOT PULLED 100 0.00 FLOW WATER JET B 10-1-7 0.00 Waterjet FLOW CNC Wateriet 1-Cut as per Dwg D3703(1Dwg Rev: A 6061.063 ****grain direction along 6.30"****[12- Deburr if necessary QC2- Inspect parts off machine FAI/FAIB 110 0.00 B10-1-7 0.00 QC Memo Quality Control

120

QC

QC8- Inspect parts - second check

Memo

Quality Control

0.00



W/O:			W	ORK ORDER CHAN	IGES					
DATE STEP		PRO	OCEDURE CHA	"	IGLO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto

Part No										
Partino):	PAR #:	Fault Cate	egory:	NC	R: Yes	No DQ	A:	_ Date: _	
Part INC		PAR #: lution:								
NCR:		lution:	Disposition		QA	: N/C C	losed:			
NCR:	Reso	lution:	Disposition	on: DER NON-CONFORI	QA	: N/C C	losed:		Date: _	
		lution:	Disposition	on: DER NON-CONFORI	QAMANCE	: N/C C	losed:			Approva
NCR:	Reso	Description of NC	Disposition WORK ORD Initial	DER NON-CONFORI Corrective Action S Action Description	QAMANCE	: N/C C	losed:	cation	Date:	Approva
NCR:	Reso	Description of NC	Disposition WORK ORD Initial	DER NON-CONFORI Corrective Action S Action Description	QAMANCE	: N/C C	losed:	cation	Date:	Approva
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NCR:	Reso	Description of NC	Disposition WORK ORD Initial	DER NON-CONFORI Corrective Action S Action Description	QAMANCE	: N/C C	losed:	cation	Date:	

Page 2

Item ID:

D3703-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Aft Doubler

Start Date:

1/05/10

Start Qty: 6.00

Required Date: 1/15/10

Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

Date:

Sn 12/02/02

Run

Start

Date: _____

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

130

Brake NC

Brake NC

Operation **Description**

QC:____

NC BRAKE

Memo

Bend as per Dwg D3703

Set Up/ **Run Hours**

Draw Number

Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

140

150

Quality Control

QC5- Inspect part completeness to step on W/O

Chemical Conversion Coat per QSI005 4.1

0.00

pk 10-3-3

Memo

Memo

HandFinish Hand Finishing 0.00

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHA	ANGES					
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
· ·										
- A1										
Part No	:	PAR #:	Fault Cate	egory:	NCI	R: Yes	No DQA	۱:	Date:	
	R	esolution:	Disposition	on:	QA	N/C CI	osed:	-	Date:	
NCR:		V	VORK ORD	ER NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC	1 1	Corrective Action	Section B	C: 0	Verific		Approval	Approval
J/11	0,2,	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion	Sign & Date	Section	on C	Chief Eng	QC Inspector
						-	- Paragraphic State			

Work Order ID 54807

December 22, 2009 1:25:43 PM



Page 3

Item ID:

D3703-1

Accept

Setup Start

Revision ID:

Item Name: **Start Date:**

Aft Doubler

1/05/10

Start Qty: 6.00

Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 1/15/10

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

10/03/03

Run

Reject

Start

Stop

Stop

Sequence ID/

Work Center ID

160

Quality Control

Operation Description

QC:

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

Draw Number

Draw Rev.

Plan Code

Accept Qty

Qty

Reject Insp. Number Stamp

170

Packaging Packaging

Identify as per dwg & Stock Location:

0.00

0.00

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

10103/05 94) MF 10-3-3

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	aES					•
DATE	ATE STEP PROCEDURE CHANGE By Date				PROCEDURE CHANGE By Date C				Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				The second secon					<u> </u>	
Part No	:	PAR #:	Fault Cat	egory:	NCR: Y	es No	DQA:		Date:	
	R	esolution:	Dispositi	on:	QA: N/C	Clos	ed:		Date: _	
NCR:			WORK ORI	DER NON-CONFORM	ANCE (N	CR)				
DATE	CTED	Description of NC			tion B		Verificat	ion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Section		Chief Eng	QC Inspector
:										
					:				•	
	1									

Picklist Print

December 22, 2009 1:25:42 PM

Work Order ID: 54807

D3703-1 Parent Item:

Parent Item Name: Aft Doubler

Comments:



Last

Start Date: 1/05/10

Qty

Issued

Required Date: 1/15/10

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Bin Primary Item Location

Route Seq ID Unit of Measure Hand

Qty on

Remaining Qty To Pick

Date Issued

Status

Page 1

M6061T6S.063

Purchased

No

Location

sf 55.7377

4.3200

S,

IR 10-1-7

6061-T6 .063 Sheet

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
MAT	55.73772105		<u></u>
110551	29.6341211		
112939	26.1036		112934



Dart Aerospace Ltd

W/O:			WORK ORDER	CHANGES					
DATE	STEP	PR	OCEDURE CHANGE	В	y C	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	ΡΔ R #·	Fault Category:	NCR: \	es No	, DO	۸-	Date:	
			Disposition:						
			WORK OPDER NON CON						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B			Annanal	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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								;
			1		1			

DART AEROSPACE LTD	Work Order: 5486	
DANT ALNOOF ACE 212		
Description: AST DoubLER	Part Number: 0 3703-1	
	Page 1 of 1	
Inspection Dwg: D3703- Rev: A	rage i or i	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.83	4 .00	16.83	X	◆ *		
4.51	7030	4,585	Sb			
4,55	4 030	4.557	4			
6,30	7 .030	6.303	~			
-063	400	.060	6	<u> </u>		
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Measured by:	B	Audited by:	Prototype Approval:	N/A
Date:	10-1-7	Date: 12/0007	Date:	N/A

ſ	Rev	Date	Change Revised by	Approved
1	Rev	Date	I KJ/JLM	
- [Α		New Issue	• • •







